

Date: Thursday, 11/9/2006 4:37:09 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 29387		
Estimate Number	: 10219		
P.O. Number	: N/A	Part Number	: D219923
This Issue	: 11/9/2006 S.O. No. : N/A	Drawing Number	: D2199 REV. E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E1
Previous Run	: N/A	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 11/25/2006
Checked & Approved By	: <i>[Signature]</i> 06/11/10	Qty:	10
Comment	: Est:D 02.06.10 Rem polish & add finishNG/CC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 2.3100 f(s)/Unit Total: 23.1000 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	Batch No: M102273 SB 06/12/07 (10)
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch per Dwg D2199 and Spec Control Dwg D2638	SB 06/12/07 (10)
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	SAN 06/12/07 (10)
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	10/06/12/11 (10)
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005.4.3	Y/S 06/12/28 (10)
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
		Comment: INSPECT POWDER COAT	Y/S 06/12/29 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51222

B 6/17/02 *DN 2/01/02*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

C 07/01/02

Job Completion



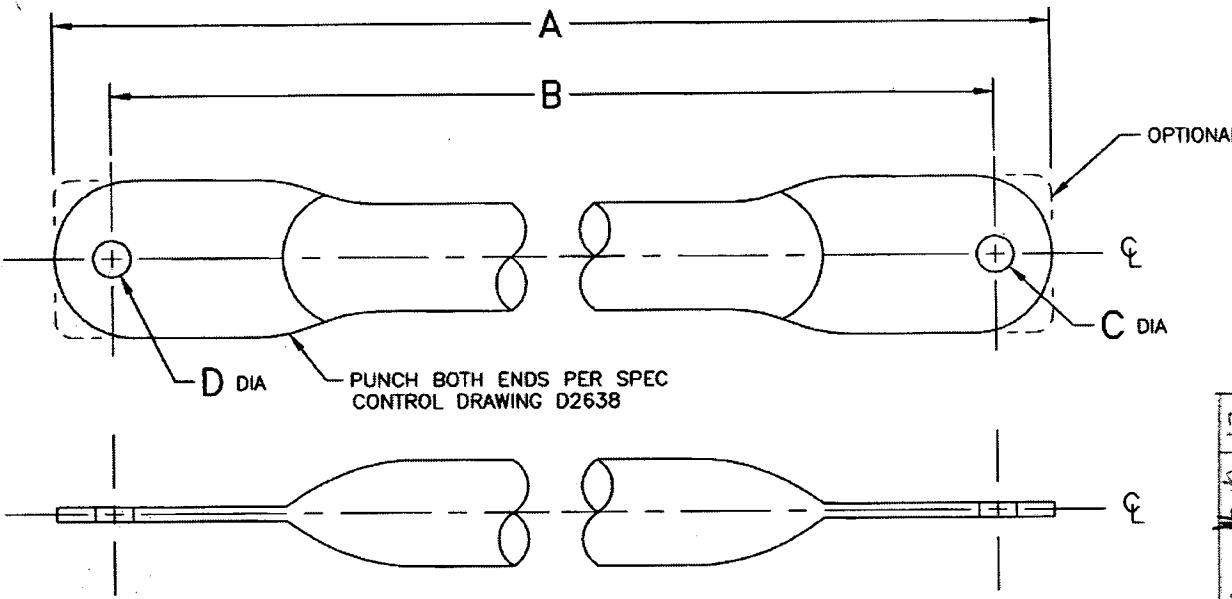
C 07/01/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

B
 B
 C
 C
 D
 E
 E

} 00.10.13
 } 00.10.13

RELEASED
 98.05.05 RE

DART

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DESIGN	DRAWN BY	DART AEROSPACE LTD	
DATE	APPROVED	HAWKESBURY, ONTARIO, CANADA	
REV.		DRAWING NO. D2199	
SHEET 1 OF 1			
SCALE			
A	1993	NEW ISSUE	
B		ADDED -11, -13, AND -15	
C		ADDED -17 AND -19	
D		ADDED -21	
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
	E1	02.03.22 ADD FINISH	

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 ENGINEERING
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 WITHOUT NOTICE
 WORK ORDER
 NO. 29387

NOTES:

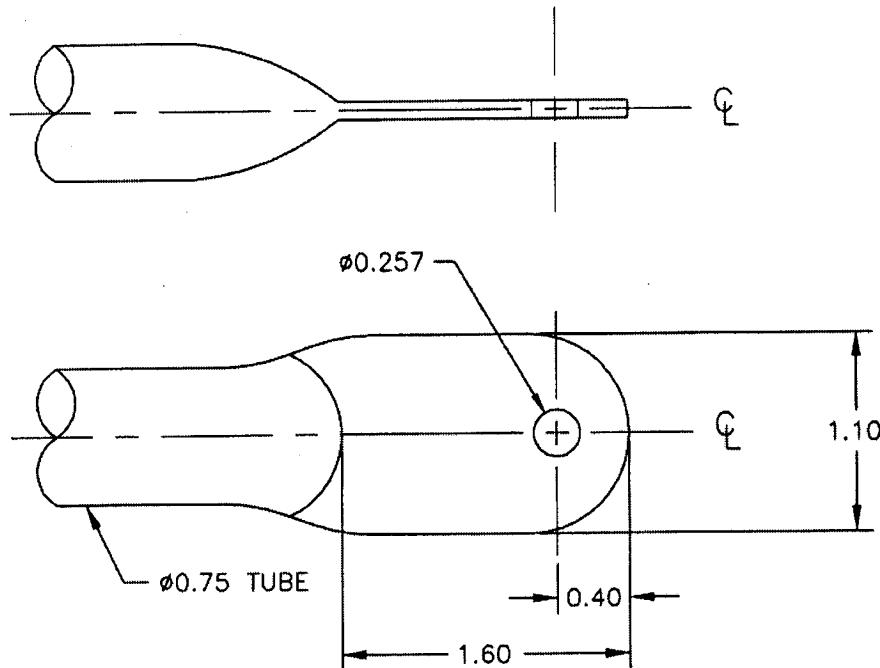
1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3/E1



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DNY	APPROVED J	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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